

Work Order ID 65904

Thursday, January 27, 2011 8:54:57 AM

Page 1

Item ID: D3564-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 1/27/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan: W

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								
100	FLOW WATER JET	0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Debur if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

B11-1-31

2

B11-1-31

+2

8/11/2/01

W/O: 65904		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-01-27	150	DETAIL D; MAKE PER CUSTOM WELDING DETAIL. THIS W/O ONLY.				11-01-27	

Part No: D3564-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65904

Page 2

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Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Deburr if necessary! Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 Form Joggle as per Dwg D3564 on brake using Jig DT8157

SB 11/02/01

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Ensure joggle as per dwg D3429

8/10/01

150

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

Qty Description Batch! I A/R
11/6/31 Weld hardcoat as per Dwg D3437

2059B Hardcoat

see attached

EL 11-27

x2

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Page 3

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Start Date: 1/27/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

8/1/08/01

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/1/08/01

(72)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:30

OVEN TEMPERATURE:

FINISH TIME:

2:00

2

BR 11-02-1.

Work Order ID 65904

Thursday, January 27, 2011 8:54:57 AM

Page 4

Push *URGENT*

Item ID: D3564-3

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Setup Start

Revision ID:

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Item Name: Wearshoe

Start Date: 1/27/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/31/2011 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/02/01 (2)

11/02/02

MF
11-02-01

Picklist Print

Thursday, January 27, 2011 8:54:54 AM

Page 1

Work Order ID: 65904

Parent Item: D3564-3

Parent Item Name: Wearshoe

Start Date: 1/27/2011

Required Date: 1/31/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	254.5000	1.1	2.315789			

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

254.5

111323

0

116623

254.5

B11-131

2

116623

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	65904
Description: Wearshoe		Part Number:	D3564-3
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

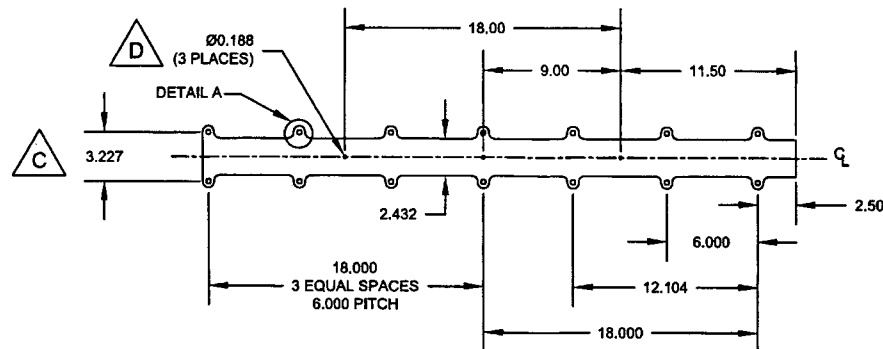
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.220	x		V RB02	
2.432	+/-0.010	2.436	x		V	
2.50	+/-0.030	2.50	x		V	
6.000	+/-0.010	6.00	x		T RB01	
12.104	+/-0.010	12.104	x		T	
18.000	+/-0.010	18.00	x		T	
18.000	+/-0.010	18.00	x		T	
18.00	+/-0.030	18.00	x		T	
9.00	+/-0.030	9.00	x		T	
11.50	+/-0.030	11.50	x		T	
0.300 x 0.300	+/-0.010	300x300	x		V	
Ø0.188	+0.005/-0.001	Ø0.189	x		V	
R0.375	+/-0.010	0.375	x		RC	
0.063	+/-0.010	0.063	x		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 11-1-31	Date: 11/6/01	Date:	N/A

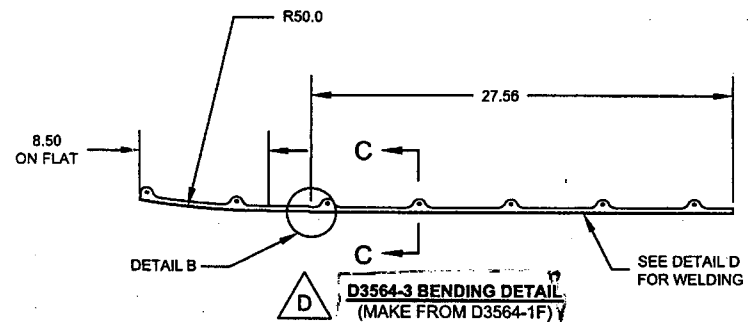
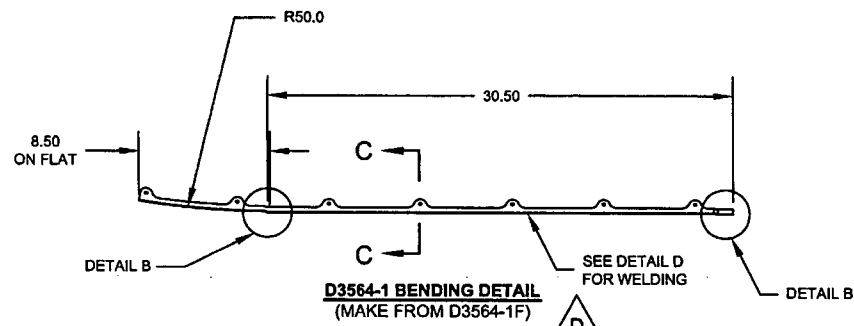
Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	



D3564-1F FLAT PATTERN

RELEASED

07.09.04



D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

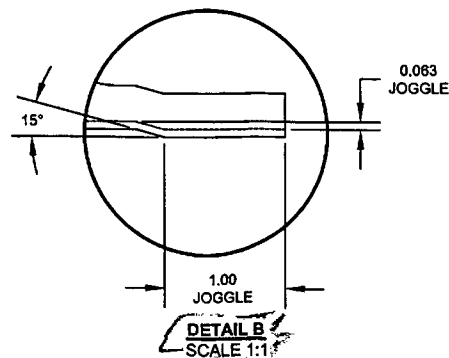
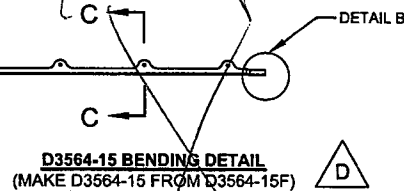
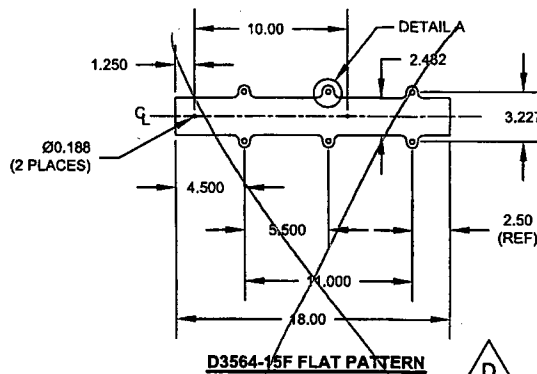
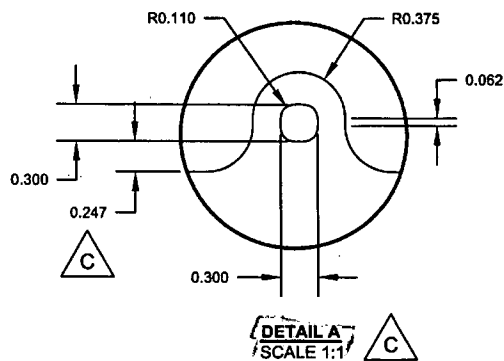
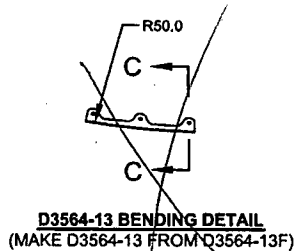
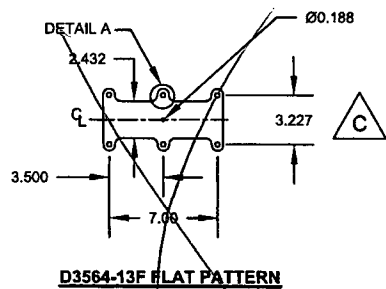
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

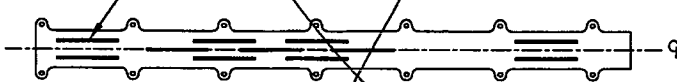
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION		DATE

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:1
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308

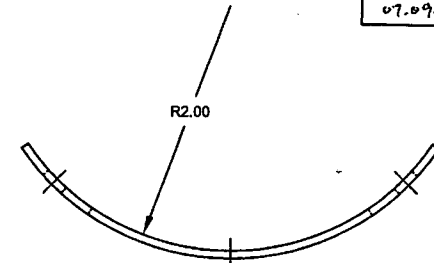


SEE ATTACHED DETAIL D

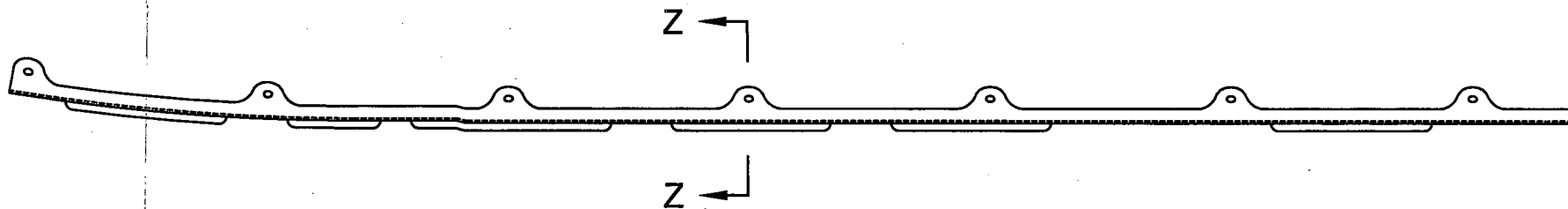
11.01.27

RELEASED

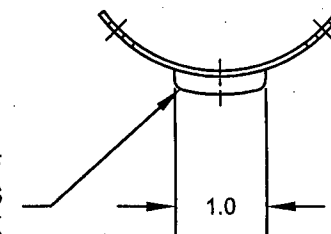
07.09.04



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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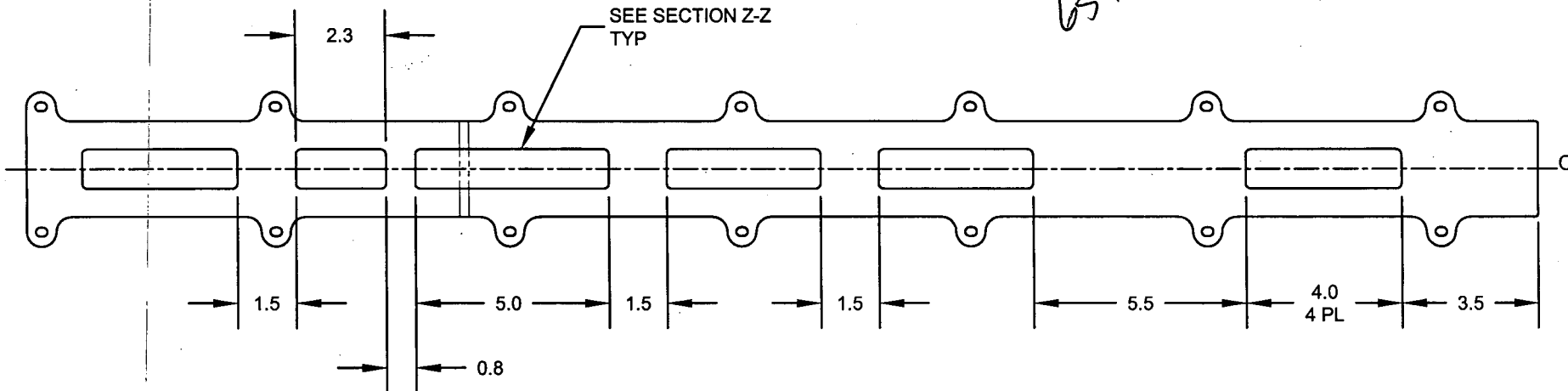
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
0.188 TO 0.250 THICK



SECTION Z-Z

65904

SEE SECTION Z-Z
TYP



DETAIL D
(D3564-3 CUSTOM WELDING DETAIL)